

BLUE

Dart Aerospace Ltd.

Date: Monday, 17/11/2008 1:53:12 PM  
User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 43489A - 1  
Estimate Number : 11702  
P.O. Number :  
This Issue : 17/11/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : / / Type : LARGE FAB ASSY  
Previous Run : 40926A  
Written By :  
Checked & Approved By : JUD 08.11.17  
Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM

Drawing Name : 206L /407 STEP ASSY, LH  
Part Number : D2724041  
Drawing Number : D2724 REV C  
Project Number :  
Drawing Revision : C  
Material :  
Due Date : 02/02/2009 Qty: 1 Um: Each

*split*

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2622120C Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion

*42155*

Check Material for any Dents or Defects

*SAD 08-12-29 (4)*

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724

Deburr and bevel ends for welding

*SAD 08-12-29 (4)*

3.0 D2734 Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number Description Batch  
2 D2734 End Cap

*339179*

*08-12-30 4*

4.0 D34581 Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D3458-1 Plate

*343085 = 1  
844002 = 1*

*08-12-30 4*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Part Number: D2724041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D34583 Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Pick:

Qty Part Number Description Batch  
2 D3458-3 Plate

343086=6 B 44003=2 11/08/12 30 4

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig

DT (One End Only)

A/R AL ROD Batch: 11103037  
11109560

Grind end cap welds flush

11/09/1.05 4  
11/09/1.05 4

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/09/01-06 4

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/09/01/06 x4 LH

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

11/09/01-06 4

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11/09/01.09 4

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

11/09/01.09 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 43489A

Part Number: D2724041

Job Number:



Seq. #: Machine Or Operation: Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: m108037

Grind per dwg D2724

*Handwritten:* 08-01-09 4  
09-01-09 4

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Handwritten:* 09-01-09 (4)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 09/01/09 (4) (41)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

*Handwritten:* (4X)

Touch up Alodine

*Handwritten:* m-h 09/01/10

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME -GREY

B 110199

-SPRAY PAINT DELFLEET BLUE

B 110077

-CLEAR DELFLEET

B 110161

*Handwritten:* RT 09-01-12

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

*Handwritten:* ml 09 01 13 (1)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

*Handwritten:* m109917 BR 09-01-28

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION




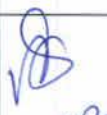





Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Handwritten:* 9/1/28 (2x) 30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2724-041 PAR #: NA Fault Category: Prod/Finishing NCR: Yes No DQA: D Date: 09/02/03  
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: D Date: 09/02/03

NCR: <u>43489A-1</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/1/15	# 17.0	Before wing walking it was found that Qty (7) step had a large mark around the step in the paint.		Sand with 320 grit paper for the entire length of step and re paint	 09/01/27	S 09/01/27	 09/01/15	S 09/01/15
		Too <del>deep</del> deep to Blend out. R.L. Painter put the elastic Band from the w/o on too soon after painting. Paint		Deflect Blue as per AS2005.	09/01/27			S 09/01/15
				Re inspect QC 14	 09/01/23	S 09/01/27		S 09/01/15
		wasn't hand turned enough Lack of Attention.						S 09/01/15

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Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



(X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PAP 43489

2/12/08

SP

20.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART****RELEASED**

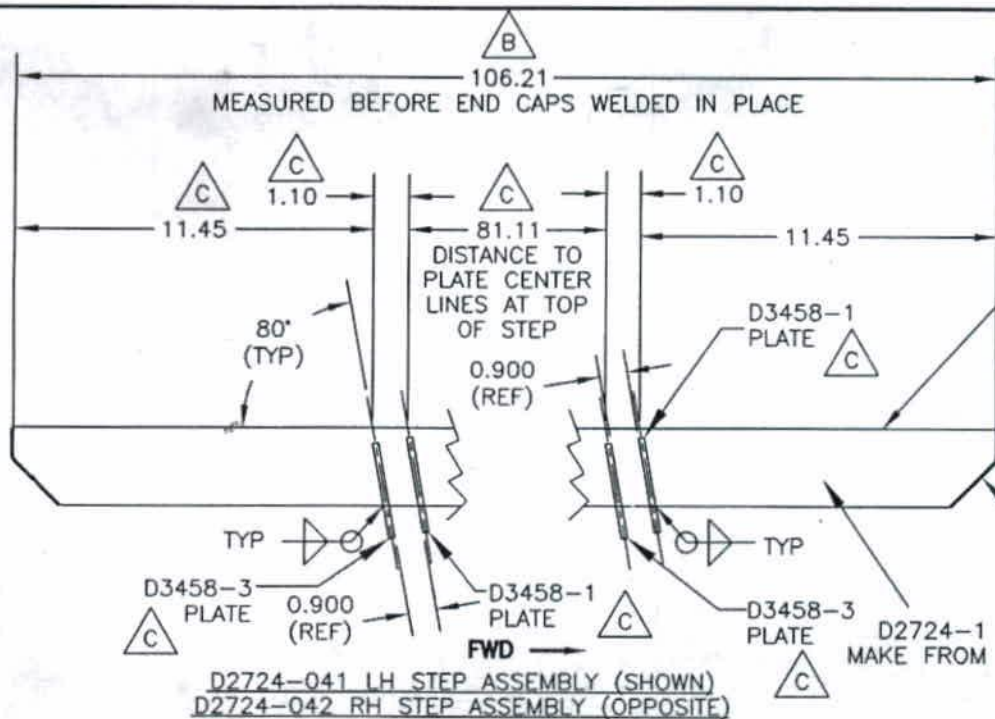
05.11.14

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004

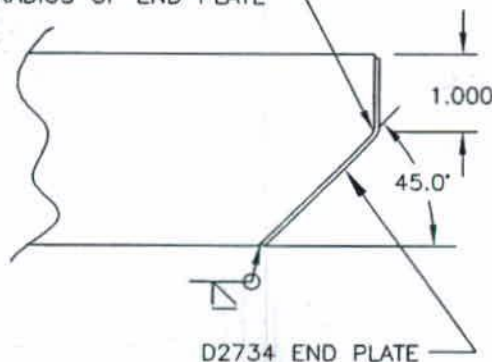
APPLY BLACK  
ANTI-SKID ON  
TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

REFER TO STEP  
END DETAIL

D2724-1  
MAKE FROM EXTRUSION D2622-107



ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE



#### D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

#### D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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PORT HADLOCK, WA

DESIGN  
KE

DRAWN BY  
PH

DRAWING NO.

D2724

TITLE

206L/407 STEP ASSEMBLY

REV. C  
SHEET 1 OF 1  
SCALE

NTS

NEW ISSUE

UPDATED WELD DETAIL  
REVISED TOLERANCES

RE-DESIGN, ADD D3458-1/-3

DATE  
05.09.19

A

97.12.04

NEW ISSUE

B

98.10.19

UPDATED WELD DETAIL  
REVISED TOLERANCES

C

05.09.19

RE-DESIGN, ADD D3458-1/-3